

Date: Tuesday, 12/5/2006 8:01:49 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SHORT STEP INSTALLATION KIT		
Job Number	: 29747					
Estimate Number	: 10542					
P.O. Number	:		Part Number	: K591113		
This Issue	: 12/5/2006	S.O. No. :	Drawing Number	: D350-591 REV F PG17		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: / /	Type : SMALL /MED FAB	Drawing Revision	: F		
Previous Run	: 28535		Material	:		
Written By	:		Due Date	: 1/10/2007 Qty: 10 Um: Each		
Checked & Approved By	:					
Comment	: Est: C 04.11.09 Reformat KJ/JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2171	Clamp	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)	
		Clamp	
		Pick:	
		Qty Part Number Description Batch	<i>B29080 -</i>
		2 D2171 Clamp	
2.0	D2182B	Neoprene Cushion-.750 bl	
		Comment: Qty.: 0.5833 f(s)/Unit Total : 5.8330 f(s)	
		Neoprene Cushion-.750 bl	
		Pick:	
		Qty Part Number Description Batch	<i>B28042 -</i>
		7"(2 x 3.5") D2182B Cushion	
3.0	D2274	Radius Block	
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)	
		Radius Block	
		Pick:	
		Qty Part Number Description Batch	<i>B28713 -</i>
		4 D2274 Radius Block	
4.0	D23623	Step Support Bracket	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)	
		Step Support Bracket	
		Pick:	
		Qty Part Number Description Batch	<i>B29436 8X - B29715 2X -</i>
		1 D23623 Support Bracket	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:01:49 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP INSTALLATION KIT

Job Number: 29747

Part Number: K591113

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D2856400 Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total : 6.0000 f(s)

Abrasion Strip

Pick:

Qty	Part Number	Description	Batch
7.2" (QTY 1)	D2856-400	Abrasion Strip	<u>32P258</u> ✓

6.0 AN337A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN3-37A	Bolt	<u>M14478</u> ✓

7.0 AN420A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
4	AN4-20A	Bolt	<u>M16895</u> ✓

8.0 AN422A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
1	AN4-22A	Bolt	<u>M17280 2P M10771 8X</u> ✓

9.0 AN960JD10 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
4	AN960JD10	Washer	<u>M6140 18X</u> ✓

M1007Y3 22X ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/01/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:01:49 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP INSTALLATION KIT

Job Number: 29747

Part Number: K591113

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0 AN960JD416

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 60.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
6	AN960JD416	Washer	M1000524X

Batch

M1000524X ✓ M102339 36X ✓

11.0 MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
2	MS21042L3	Nut	M101917

Batch

M101917 ✓

12.0 MS21042L4

Nut



Comment: Qty.: 5.0000 Each(s)/Unit Total : 50.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
5	MS21042L4	Nut	M996348X

Batch

M996348X M191852X - 12/5/21

13.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

C20710111

(ID)

14.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

✓/A

15.0 QC21

FINAL INSPECTION/W/O RELEASE



(P)

Comment: FINAL INSPECTION/W/O RELEASE

C20710111

Job Completion



12/5/2011

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5. PARTS LIST

Qty -111A	Qty -113	Qty -115	Qty -117A	Qty -119	Qty -133	Part Number	Description
X						D350-591-111A	Heli-Access-Step™, Long Step – High Skid
	X					D350-591-113	Heli-Access-Step™, Short Step – High Skid
		X				D350-591-115	Heli-Access-Step™, Short Step – Low Skid
			X			D350-591-117A	Heli-Access-Step™, Pre-Flight Step
				X		D350-591-119	Heli-Access-Step™, Long Step – Low Skid
					X	D350-591-133	Heli-Access-Step™, Aft Maintenance Step
						D2310	STEP ASSEMBLY (HIGH-SHORT)
1						D2311	STEP ASSEMBLY (HIGH-LONG)
	1					D2354	STEP ASSEMBLY (LOW-SHORT)
				1		D2355	STEP ASSEMBLY (LOW-LONG)
					1	D2946-041	STEP ASSEMBLY (MAINTENANCE)
4	2	2	2	2		D2171	CLAMP
4	2	2	2	2		D2182B035	CUSHION
					4	D2230-1	MOUNTING LUG
					4	D2230-3	MOUNTING LUG
8	4	4	4	4		D2274	RADIUS BLOCK
				1		D2362-041	SUPPORT BRACKET
2	1				1	D2362-3	SUPPORT BRACKET
					1	D2362-5	SUPPORT BRACKET
2	1	1	1	1	2	D2856-400-720	ABRASION STRIP
					1	D2945	MOUNTING PLATE
2	2	2			2	AN3-37A	BOLT
					2	AN4-7A	BOLT
					4	AN4-11A	BOLT
					8	AN4-14A	BOLT
8	4	4	4	4		AN4-20A	BOLT
1	1	1			1	AN4-22A	BOLT
4	4	4			4	AN960JD10	WASHER
10	6	6	4	6	14	AN960JD416	WASHER
2	2	2		2		MS21042L3	NUT
9	5	5	4	5	14	MS21042L4	NUT

Qty -121	Qty -122	Qty -123	Qty -124	Part Number	Description
X				D350-591-121	Heli-Access-Step™, Short Step – High Skid, LH
	X			D350-591-122	Heli-Access-Step™, Short Step – High Skid, RH
		X		D350-591-123	Heli-Access-Step™, Short Step – Low Skid, LH
			X	D350-591-124	Heli-Access-Step™, Short Step – Low Skid, RH
				D2351-041	STEP ASSEMBLY (HIGH-SHORT, LH)
1			1	D2351-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1		D2356-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1	D2356-042	STEP ASSEMBLY (LOW-SHORT, RH)
1	1	1	1	D2230-1	MOUNTING LUG
1	1	1	1	D2230-3	MOUNTING LUG
1	1	1	1	D2856-400-720	ABRASION STRIP
2	2	2	2	AN3-37A	BOLT
3	3	3	3	AN4-13A	BOLT
4	4	4	4	AN960JD10	WASHER
6	6	6	6	AN960JD416	WASHER
2	2	2	2	MS21042L3	NUT
3	3	3	3	MS21042L4	NUT

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RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29747